

**Work Order ID 62006**

Page 1

Tuesday, September 14, 2010 1:17:04 PM

Item ID: D3535-13

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 9/14/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 9/21/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

P1

Date: 10-9-14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3535	Rev B

100 0.00



FLOW WATER JET

Waterjet

Memo

0.00

10-9-14

FLOW CNC Waterjet

1-Cut as per Dwg D3535  Dwg Rev: S  Prog Rev: B  2-  
Deburr if necessary

(3)

110 0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

10-9-14

Quality Control

120 0.00



QC8- Inspect parts - second check

QC

Memo

0.00

S.09/15

X13

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 62006**

Tuesday, September 14, 2010 1:17:04 PM



Page 2

Item ID: D3535-13

Revision ID:

Item Name: Wearshoe

Start Date: 9/14/2010 Start Qty: 12.00

Accept



Setup

Start



Required Date: 9/21/2010 Req'd Qty: 12.00



Cust Item ID:



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

130

Operation  
Description

NC BRAKE

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Brake NC

Brake NC

Memo

0.00

13

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S10/09/14

X13

150



Powdercoat

Powder Coating

Grey Sandtex(Ref.4.3.5.6) per QSI005 4.3

0.00

BL 10-9-20

13

M112588

Memo

0.00

START TIME:

11:45

OVEN TEMPERATURE:

320

13.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

**Work Order ID 62006**

Tuesday, September 14, 2010 1:17:04 PM



Page 3

Item ID: D3535-13

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 9/14/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 9/21/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

=) Ml 10/09/20

0.00

13

P

170



Packaging

Packaging

Identify as per dwg &amp; Stock Location

TP-A.

0.00

BF 10-9-20

0.00

B

P

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/09/21

MF

10-9-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Tuesday, September 14, 2010 1:17:08 PM

Page 1

Work Order ID: 62006



Parent Item: D3535-13



Parent Item Name: Wearshoe

Start Date: 9/14/2010

Required Date: 9/21/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-15 JLM  
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 		Purchased		No		100	sf	70.6987	0.8505	10.74316	11.1	HB10-9-14	

304/316 .040 Sheet

Location	Loc Qty	Loc Code
MAT	16.1522	
114574	16.1522	
MAT20	54.5465	
112885	2.7475	
113062	0.699	
115440	51.1	115440

(13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	62006
Description: Wearshoe		Part Number:	D3535-13
Inspection Dwg: D3535	Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.889	✓		✓ 1B02	
2.000	+/-0.010	2.000	✗		✓	
5.650	+/-0.010	5.650	✗		T 1B01	
9.150	+/-0.010	9.150	✗		T	
14.066	+/-0.010	14.066	✗		T	
18.983	+/-0.010	18.983	✗		T	
23.900	+/-0.010	23.900	✗		T	
27.400	+/-0.010	27.400	✗		T	
29.400	+/-0.010	29.400	✗		T	
32.900	+/-0.010	32.900	✗		T	
Ø0.188	+0.005/-0.001	1.88	✗		✓	
20.00	+/-0.030	20.00	✗		T	
14.00	+/-0.030	14.06	✗		T	
8.00	+/-0.030	8.00	✗		T	
5.00	+/-0.030	5.00	✗		T	
0.300	+/-0.010	301	✗		✓	
0.300	+/-0.010	300	✗		✓	
0.038	+/-0.010	036	✗		✓	

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	10-04-14	Date:	10/05/15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.15	New Issue	KJ/DD	BB

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

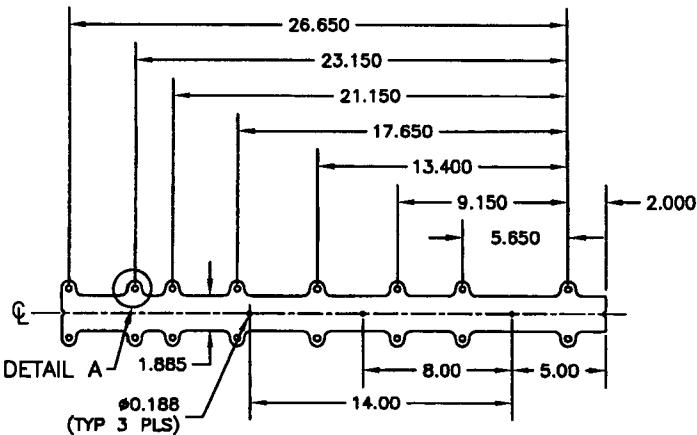
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

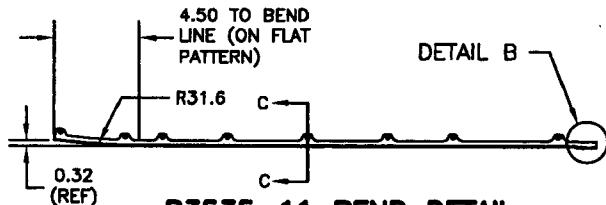
**DART**

RELEASED

1024

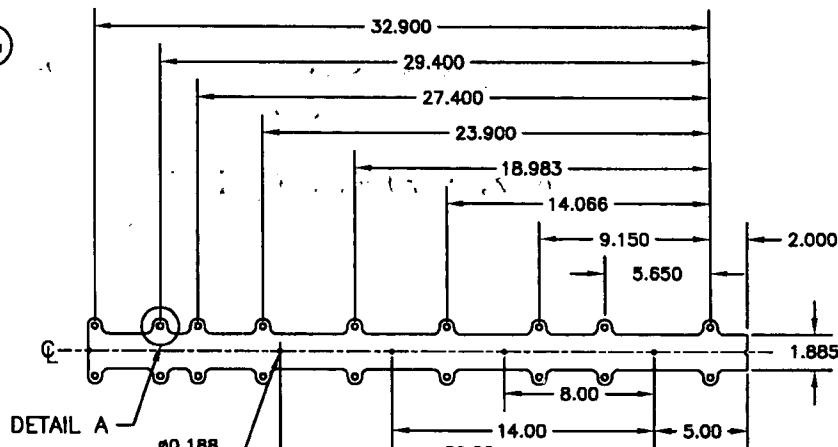


**D3535-11F FLAT PATTERN**

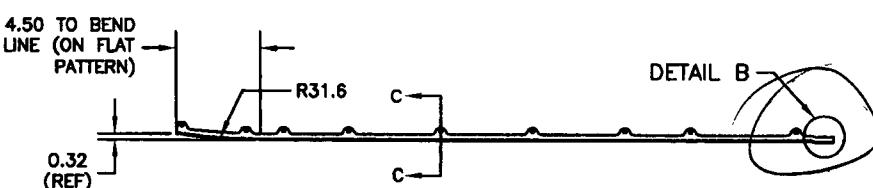


**D3535-11 BEND DETAIL**

UNCOMING PRACTICALLY  
SUBJECTS OF STUDY  
VI  
W  
NO class



**D3535-13F FLAT PATTERN**



**D3535-13 BEND DETAIL**

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AM  
20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5)  
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE  
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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DESIGN <b>CB</b>		DRAWN BY <b>PH</b>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA		
CHECKED <del>PH</del>	APPROVED <del>PH</del>		DRAWING NO. D3535	SHEET 1 OF 7	REV. B
DATE 07.04.17	TITLE WEARSHOE		SCALE 1:10		
A B	06.10.25 07.04.17	NEW ISSUE MOVE TAB OUTBOARD, ADD AMS SPEC			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

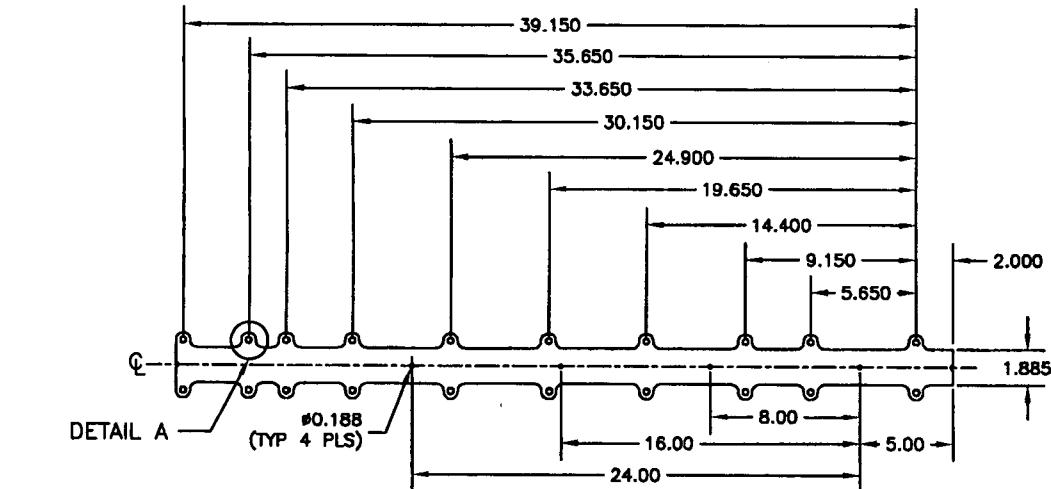
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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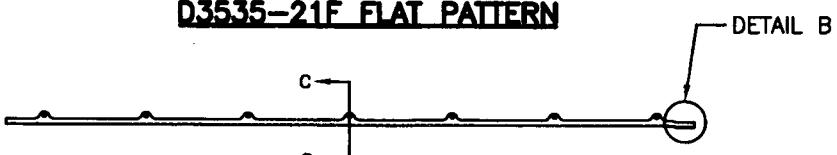
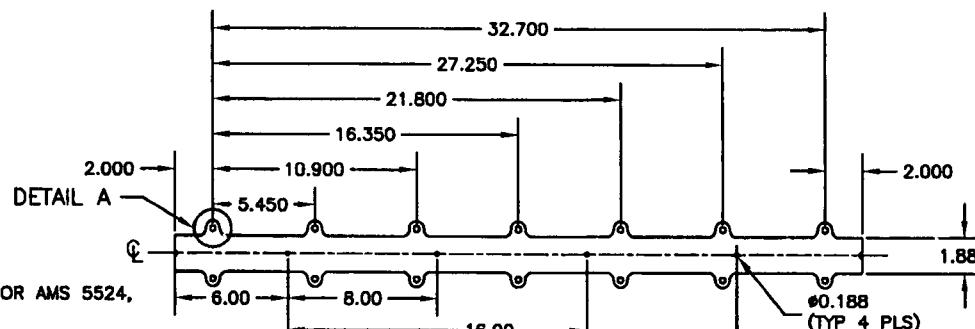
NOTE: Date & initial all entries

**DART**RELEASED  
07.04.17

W/0 42606



**D3535-15 BEND DETAIL**

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN CB	DRAWN BY RH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED H	APPROVED H	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 2 OF 7 SCALE 1:10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

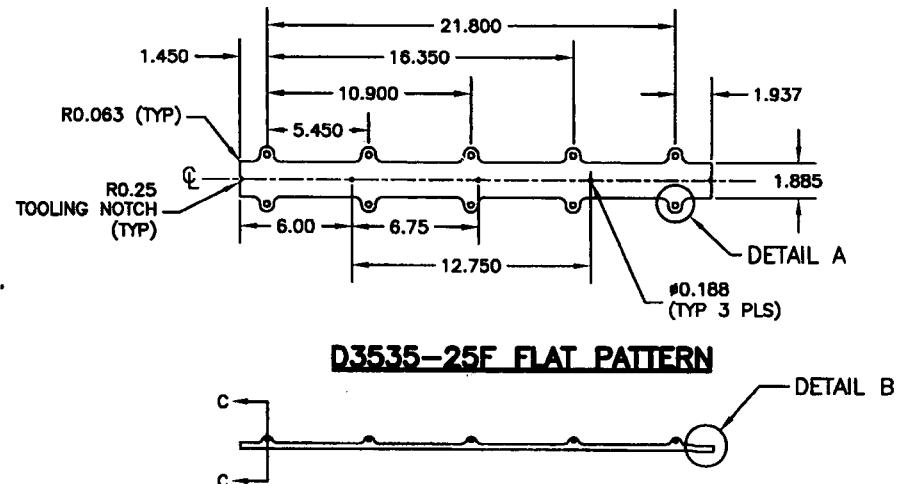
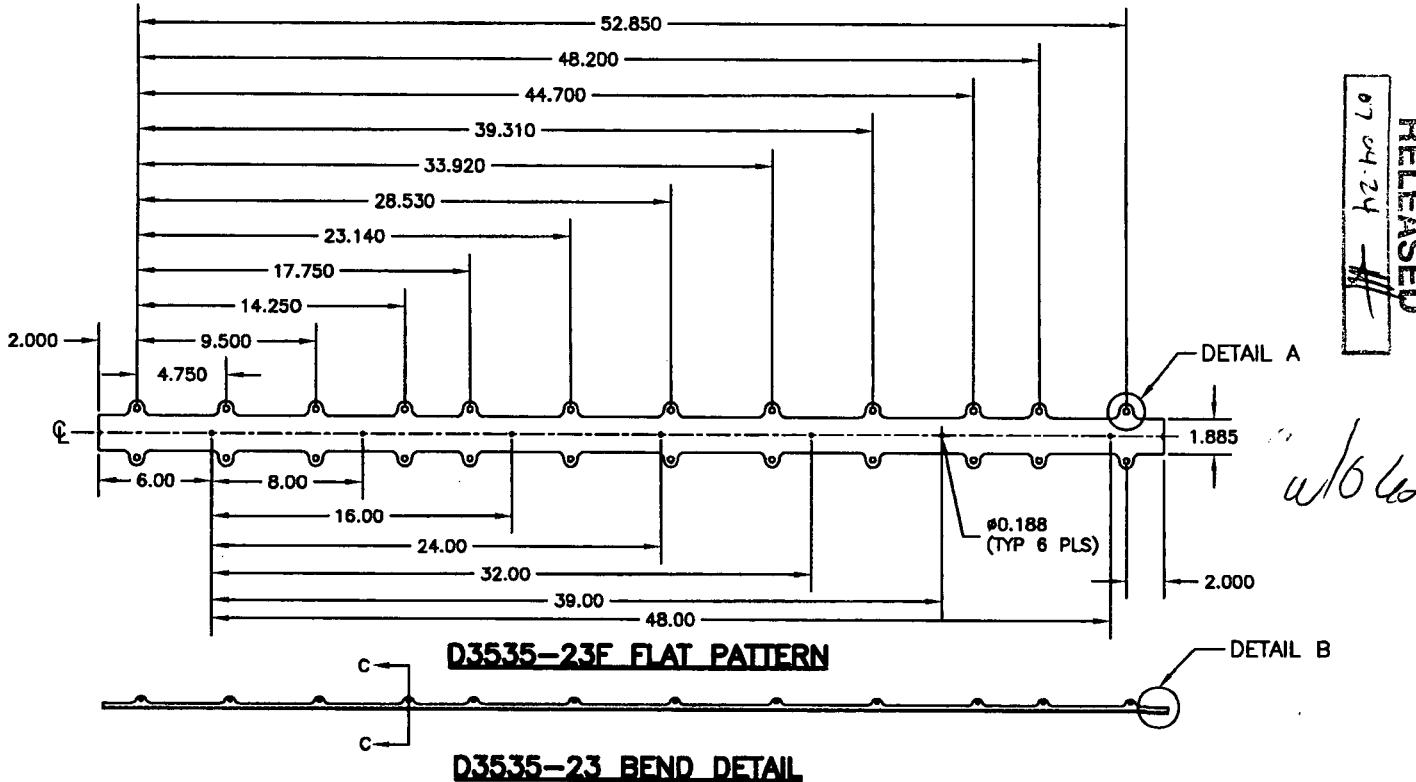
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <b>CB</b>	DRAWN BY <b>MH</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <b>M</b>	APPROVED <b>M</b>	DRAWING NO. <b>D3535</b>
DATE <b>07.04.17</b>	TITLE <b>WEARSHOE</b>	REV. B SHEET 3 OF 7 SCALE <b>1:10</b>

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\frac{C}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

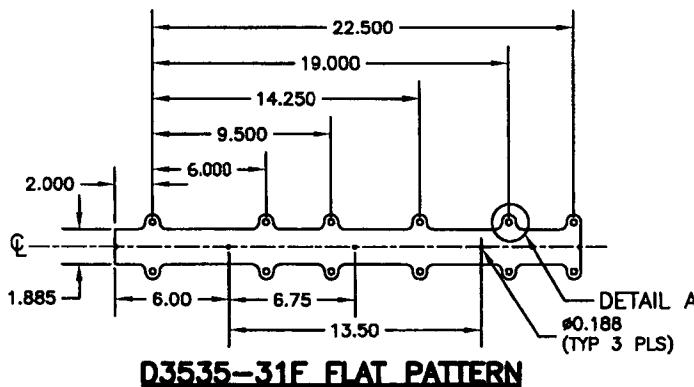
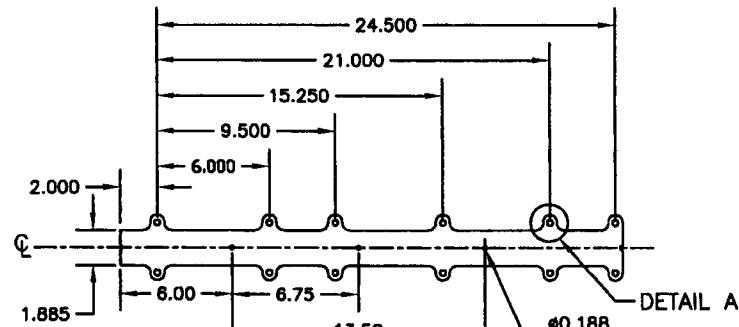
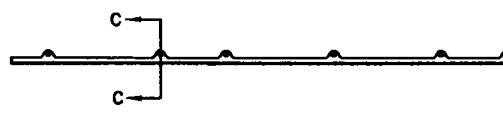
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NOTE: Date & initial all entries

**DART**

DESIGN <b>C.B</b>	DRAWN BY <b>PH</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <b>W</b>	APPROVED <b>W</b>	DRAWING NO. <b>D3535</b>
DATE <b>07.04.17</b>	TITLE <b>WEARSHOE</b>	REV. B SHEET 4 OF 7 SCALE <b>1:10</b>

RELEASED  
07.04.24  
W

**D3535-31 FLAT PATTERN****D3535-31 BEND DETAIL****D3535-33 FLAT PATTERN****D3535-33 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\frac{C}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
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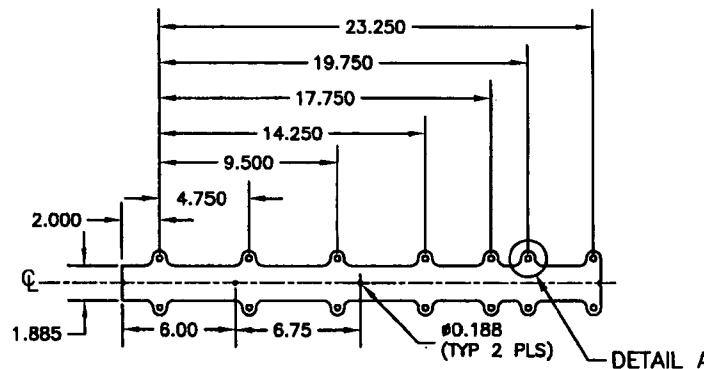
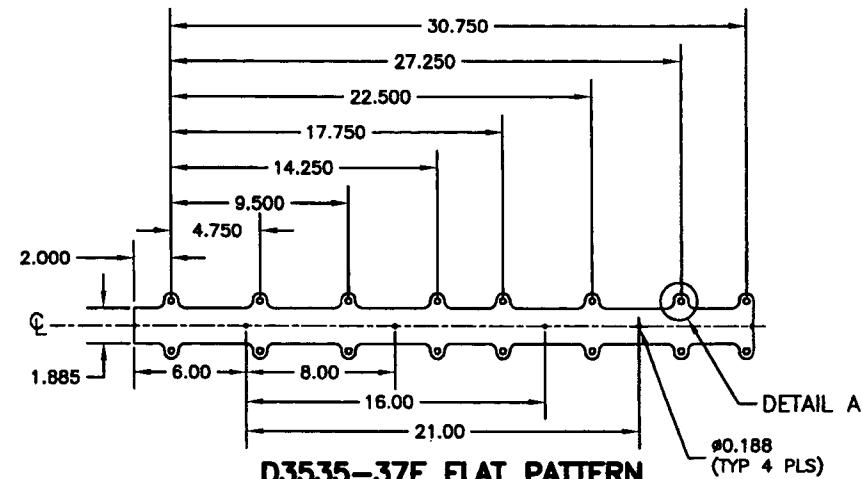
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**DART**RELEASED  
07.04.24**D3535-35F FLAT PATTERN****D3535-35 BEND DETAIL****D3535-37F FLAT PATTERN****D3535-37 BEND DETAIL**

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
C8	PH	PRT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
MM	MM	D3535
DATE		REV. B
07.04.17		SHEET 5 OF 7
		SCALE
		1:10
		WEARSHOE

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524.  
20 GAUGE (0.038 THICK)  
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- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER  
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

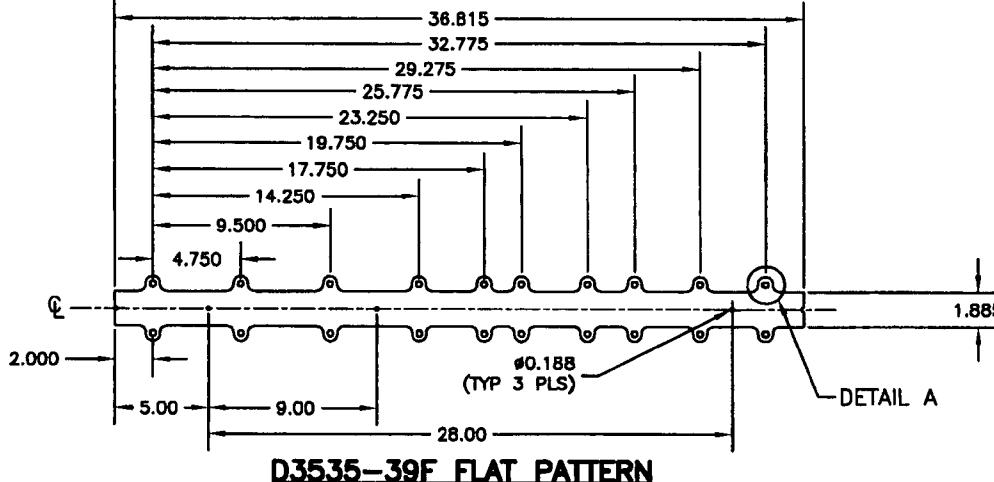
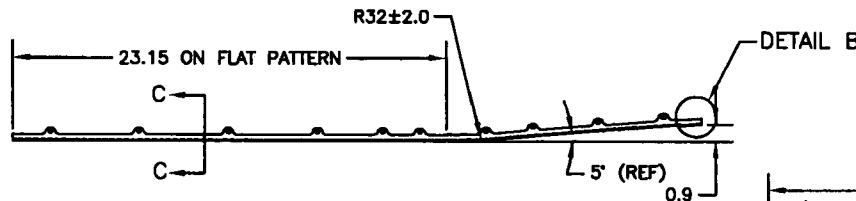
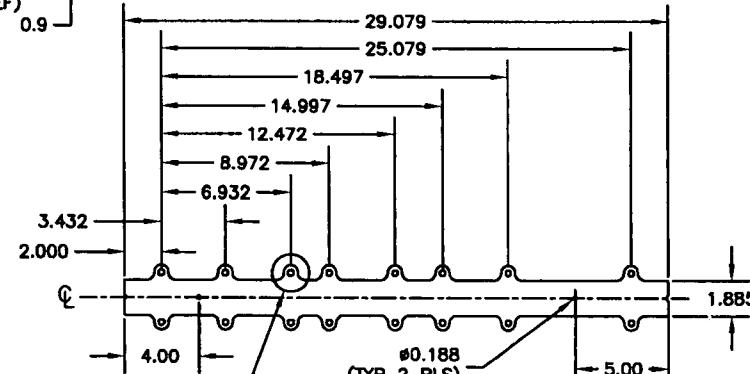
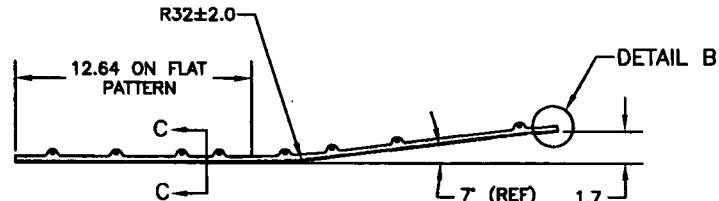
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
C.B	<i>PH</i>	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
<i>MM</i>	<i>MM</i>	D3535
DATE	TITLE	SCALE
07.04.17	WEARSHOE	1:10

RELEASED  
07.04.24  
*WB 42002*

**D3535-39F FLAT PATTERN****D3535-39 BEND DETAIL****D3535-41F FLAT PATTERN****D3535-41 BEND DETAIL**

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

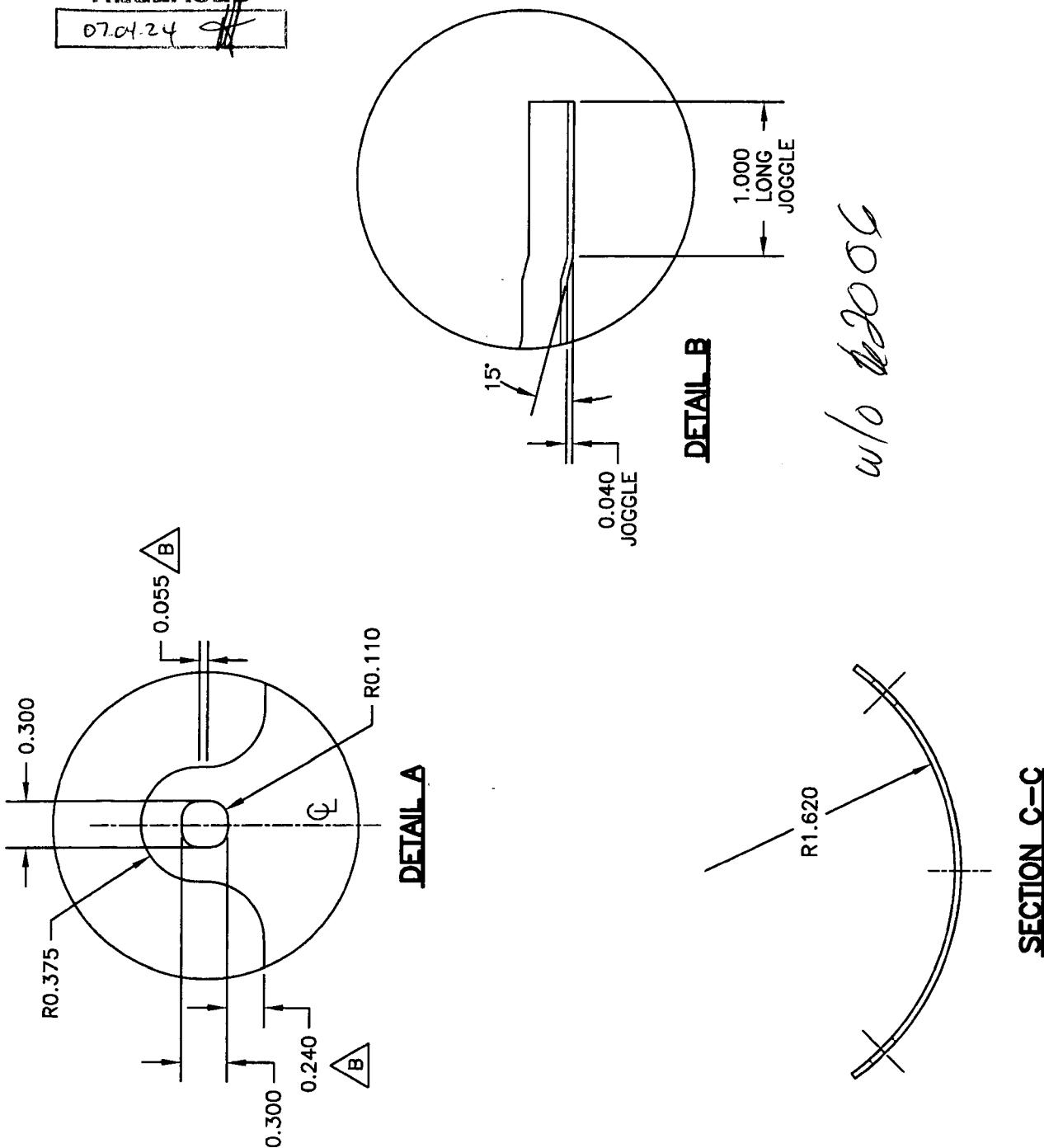
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>CB</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17		TITLE WEARSHOE	SCALE 1:1

RELEASED

07.04.24 *[initials]*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries